

Ship 16/06

Work Order ID 120655

120655

Page 1

June-10-14 7:44:13 AM

Item ID: D350-567-145

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 6/10/14 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 6/16/14 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9590	E

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								

DAS
06
9-89

JUN 17 2014

3

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS
32
9-89

17/6/14 (3)

DAS
31
9-89

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
06
9-89

JUN 17 2014 3

Work Order ID 120655

120655

Page 2

June-10-14 7:44:13 AM

Item ID: D350-567-145 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Window Close Out (AS350 B3e)
Start Date: 6/10/14 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 6/16/14 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-145								
	Location: 16 027								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-06-17

MF 14-6-17

Picklist Print

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Page 1

Work Order ID: 120655

120655

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 6/10/14

Required Date: 6/16/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CB200		Purchased	No				Each	23.0000	3			DAS 32 9-89	DAS 32 9-89
<div> <div>3</div> <div> <div>*CB200*</div> <div>Acrylic Adhesive 3.5G</div> <div>DAS</div> <div>06</div> <div>9-89</div> </div> </div>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST264			23						
				m129423			23						
D4730-020-030		Manufactured	No				Each	8.0000	3			DAS 32 9-89	DAS 32 9-89
<div> <div>3</div> <div> <div>*D4730-020-030*</div> <div>Velcro Strip 2.0W/ X 3.0L</div> <div>DAS</div> <div>06</div> <div>9-89</div> </div> </div>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST			8						
				120056			8						
D4974-041		Manufactured	No				Each	0.0000	3			DAS 32 9-89	DAS 32 9-89
<div> <div>3</div> <div> <div>*D4974-041*</div> <div>T/R Bellcrank Cover Assembly</div> <div>DAS</div> <div>06</div> <div>9-89</div> </div> </div>													
D5076-041		Manufactured	No				Each	1.0000	3			DAS 32 9-89	DAS 32 9-89
<div> <div>3</div> <div> <div>*D5076-041*</div> <div>Fwd Bracket Assembly</div> <div>DAS</div> <div>06</div> <div>9-89</div> </div> </div>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST			1						
				115466			1						

6

M129423

125056

120660

B 120933 24

115466 1p

Picklist Print

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Page 2

Work Order ID: 120655

120655

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 6/10/14

Required Date: 6/16/14

Start Qty: 3.00

Required Qty: 3.00

D3802-1

Manufactured No

f

221.0000

6

DAS
32
9-89

D3802-1

Windows Seal (\$ Per Foot)

DAS
06
9-89

DAS
27
9-89

3824" SH

Location

Loc Qty

Loc Code

ST411

221

112283

48

114190

9

116673

110

117766

50

81868

4

117766 20
81868 40

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9

Manufactured No

Each

11.0000

6

DAS
32
9-89

D4435-9

Bracket

Location

Loc Qty

Loc Code

ST273

11

109304

11

109304

D4436-04189

Manufactured No

Each

3.0000

3

DAS
32
9-89

D4436-041

Aft Bracket Assembly

DAS
06
9-89

Location

Loc Qty

Loc Code

ST271A

1

109823

1

ST272

2

115041

2

115041 20
B115409 10

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 120655

120655

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 6/10/14

Required Date: 6/16/14

Start Qty: 3.00

Required Qty: 3.00

D4441-1

Manufactured No

f

90.0000

2 6

DAS
32
9-89

3 *D4441-1*

Rubber Seal

Box 24" SWF

Location

Loc Qty

Loc Code

ST407

90

86185

90

86185

DAS
31
9-89

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A

Purchased No

Each

350.0000

15

DAS
32
9-89

3 *AN3-3A*

Bolt

Location

Loc Qty

Loc Code

ST350

350

m126249

1

m127815

4

m128429

145

m128973

200

m128429

DAS
31
9-89

DAS
06
9-89

AN525-10R6

Purchased No

Each

188.0000

6

DAS
32
9-89

3 *AN525-10R6*

Screw

Location

Loc Qty

Loc Code

ST329

100

M129390

100

ST344

88

M127743

88

m127743

DAS
31
9-89

DAS
06
9-89

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Work Order ID: 120655

Parent Item: D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

120655

D350-567-145

Start Date: 6/10/14

Required Date: 6/16/14

Start Qty: 3.00

Required Qty: 3.00

AN525-832R7

Purchased

No

Each

146.0000

6

DAS
32
9-89

AN525-832R7

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

13

120560

13

ST344

133

m127363

133

Each

398.0000

21

DAS
31
9-89

MS21042L06

Purchased

No

MS21042L06

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

398

m127304

3

m128401

195

m128976

200

Each

5,144.000

6

DAS
31
9-89

MS21042L08

Purchased

No

MS21042L08

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

3211

123900

58

m128401

1500

m128429

1653

ST508

1834

125445

436

m127410

1398

ST509

99

m127304

99

DAS
31
9-89

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Picklist Print

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Work Order ID: 120655

120655

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 6/10/14

Required Date: 6/16/14

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

Each

6,079.000

15

MS21042L3

Nut

**

DAS

32
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

109

108816

9

M127410

13

M127831

39

M128401

48

ST506

955

123900

955

ST509

5015

M127831

2

M128754

5013

M128754

MS21059L3

Purchased

No

Each

299.0000

6

MS21059L3

Nut Plate

**

DAS

32
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST315

297

114449

4

M128300

97

M128936

96

M128976

100

ST316

2

M127743

2

M128300 3X
M128936 3X

MS35206-229

Purchased

No

Each

70.0000

21

MS35206-229

Screw

**

DAS DAS

32 31
9-89 9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST288

70

M126084

70

M126084

14/4/11 (3)

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Shop Packet Print

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Picklist Print

June-10-14 7:44:13 AM

Work Order ID: 120655

120655

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 6/10/14

Required Date: 6/16/14

Start Qty: 3.00

Required Qty: 3.00

NAS1149F0332P

Purchased

No

Each

4,938.000

30

**

DAS
32
9-89

NAS1149F0332P

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

GA	205
122063	205
ST295	2083
123900	12
m123185	34
m128401	2037
ST510a	2632
125646	132
m127831	2500
ST522	18
m123185	18

m128401

DAS
31
9-89

NAS1149FN616P

Purchased

No

Each

348.0000

42

**

DAS
32
9-89

NAS1149FN616P

WASHER

DAS
06
9-89

Location

Loc Qty

Loc Code

ST294	348
M127703	348

m127703

DAS
31
9-89

NAS1149FN816P

Purchased

No

Each

594.0000

6

**

DAS
32
9-89

NAS1149FN816P

WASHER

DAS
06
9-89

Location

Loc Qty

Loc Code

ST294	594
117316	594

m117316

DAS
31
9-89

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1	1	D4434-041	FWD BRACKET ASSEMBLY
	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure



Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.20
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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